

Reprint

Work Order ID 106018

106018

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December-02-13 7:41:36 AM

Item ID: D350-740-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aircraft Disabling Device

Start Date: 8/28/13 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 8/28/13 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A	Rev N/A								
100	DOCUMENT CONTROL	0.00	DAS	27					
100			9-89	13/12/13		2			
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D350-740-011 CHG002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00	DAS	27					
120			9-89	13/12/13		2			
QC	Memo	0.00							
Quality Control	Ensure that keys can be locked and unlocked for each D3371-041 and D3372-041 assembly.								

2 13-12-3 52

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Page 2

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Setup Start

NS1

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2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

PACKAGING RESOURCE #1 Identify and pack for shipping as

per PPP D350-740-011 Location: _____ PPP

Rev: _____ Record Key Numbers For The Following: D3371-

041 D3372-041 _____

2x *8* *13-12-3*

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

13/12/03
MF
13-12-03

Picklist Print

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Work Order ID: 106018
 Parent Item: D350-740-011
 Parent Item Name: Aircraft Disabling Device

Start Date: 8/28/13
 Start Qty: 2.00

Required Date: 8/28/13
 Required Qty: 2.00

Comments: IPP Rev:E Re-Format 06-01-13 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3371-041
 Tail Rotor Pedal Lock

DAS
 27
 9-89 27

Manufactured No

120 Each 6.0000

1

2

SD

27

Location

Loc Qty

Loc Code

ST490A

6

6

87179

110 Each 7.0000

1

2

SD

27

Location

Loc Qty

Loc Code

ST471

2

107952

2

ST491

5

104213

1

104948

1

105705

3

DAS
 27
 9-89

27

- 3.3.3 Place the D3384-043 Collective Sock over the collective control stick as shown in Figure 2.
- 3.3.4 Unlock/open the collective lock and secure around the aircraft collective control base by aligning the shaft of the lock device with the hole in the collective base as shown in Figure 2. Engage cam and lock D3372-051/ D3400-051 Collective Lock Assembly with the provided key. Ensure that the device is locked and will not open.

3.4 D3372-041/ D3400-041 COLLECTIVE DISABLING KIT REMOVAL

- 3.4.1 Unlock D3372-051/ D3400-051 Collective Lock Assembly from the collective control base using the provided key. Open the lock, and remove from the collective control base.
- 3.4.2 Remove D3384-043 Collective Sock from the collective control stick.

4.0 PARTS LIST

011	-013	Part Number	Description
X		D350-740-011	DUAL DISABLING KIT
	X	D355-740-013	DUAL DISABLING KIT
1	1	D3371-041	TAIL ROTOR PEDAL DISABLING KIT
1	1	D3371-051	* PEDAL LOCK ASSEMBLY
1	1	D3384-045	* CYCLIC SOCK
1	1	HX-81	* 1/4" -20 SOCKET HEAD CAP SCREW
2	2	AN960-416	* WASHER
1	1	D3373-7K	*** KEY, REPLACEMENT
1		D3372-041	COLLECTIVE DISABLING KIT
1		D3372-051	* COLLECTIVE LOCK-ASSEMBLY
1		D3384-043	** COLLECTIVE SOCK
1		HX-81	** 1/4" -20 SOCKET HEAD CAP SCREW
2		AN960-416	** WASHER
1		D3373-1K	*** KEY, REPLACEMENT
	1	D3400-041	COLLECTIVE DISABLING KIT
	1	D3400-051	* COLLECTIVE LOCK ASSEMBLY
	1	D3384-043	** COLLECTIVE SOCK
	1	HX-81	** 1/4" -20 SOCKET HEAD CAP SCREW
	2	AN960-416	** WASHER
	1	D3373-1K	*** KEY, REPLACEMENT

* shown for reference only, part is included in D3371-041 assembly above

** shown for reference only, part is included in D3372-041/ D3400-041 assembly above

*** shown for reference only, p/n for ordering replacement keys

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Tooling:

Date:

Run Start *NR1*

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SPC (Y/N):

Date:

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Quality Control	Ensure that keys can be locked and unlocked for each D3371-041 and D3372-041 assembly.								

C420A

MLJ 13-12-03

(Handwritten signature/initials)